

Date
UserWednesday, 15/08/2007 4:09:55 PM
Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOAT SKIDTUBE
Job Number	: 33973		
Estimate Number	: 10366		
P.C. Number	: <i>N/A</i>	Part Number	: D412742013
This Issue	: 15/08/2007 S.O. No. : <i>N/A</i>	Drawing Number	: N/A UNDER REVIEW
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : LANDING GEAR	Drawing Revision	: N/A
Previous Run	: 33972	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 10/09/2007 Qty: 1 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est Rev: A 05.10.13 New Issue KJ/JLM Est Rev: B 06-06-08 As per DSI9336 JLM		

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0 DC

DOCUMENT CONTROL

*KS 07-08-30*

Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D412-742-013 CHG003

Er 07/09/12

2.0 33973A

FLOAT SKID ASSEMBLY



Comment: Sub-Component FLOAT SKID ASSEMBLY

D412-742-043 B *33973A*

3.0 D2571

Saddle, Fwd, Out



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2571 Saddle Fwd Outside

D32165

4.0 D2572

Saddle, Fwd, In



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2572 Saddle Fwd Inside

*D31720**Er 07/09/11*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 4:09:55 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 33973

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

D2573

Saddle, Aft, Out



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2573 Saddle Aft Outside B31721

6.0

D2574

Saddle, Aft, In



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2574 Saddle Aft Outside B32168

7.0

D2747

Set Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D2747 Bolt B33470

8.0

D2876

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2876 Saddle Spacer B31227

9.0

D2877

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2877 Saddle Spacer B32104

10.0

D34031

Bushing



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 D3403-1 Bushing B33562

B33786

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 33973

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D34033

Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 D3403-3

Bushing

D 32889

12.0

D3405041

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3405-041

GHW Lug

D 32890

13.0

D3405043

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3405-043

GHW Lug

D 32891

14.0

AN4C6A

Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 AN4C6A

Bolt

M104603

15.0

AN4C46A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4C46A

Bolt

M19529

16.0

AN4C52A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN4C52A

Bolt

M100340

EP 15/08/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 4:09:55 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 33973

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

AN6C12A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN6C12A

Bolt

M104289

18.0

AN960C416L

WASHER



Comment: Qty.: 32.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

32 AN960C416L

Washer

M104936

19.0

AN960C616L

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN960C616L

Washer

M18822

20.0

AN960C716L

WASHER



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 AN960C716L

Washer

M104093

21.0

MS210434

Nut



Comment: Qty.: 29.0000 Each(s)/Unit Total: 29.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

29 MS21043-4 Nut

M105115

EP 07/09/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 4:09:55 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 33973

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description:

22.0

NAS1515H4L

WASHER



Comment: Qty.: 32.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick:

Qty Part Number
32 NAS1515H4L

Description
Washer

Batch

M105211 (B1X) M105408 (2) -

23.0

NAS1515H6L

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number
8 NAS1515H6L

Description
Washer

Batch

M18918 -

24.0

NAS1515H7L

WASHER



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number
16 NAS1515H7L

Description
Washer

Batch

M100727 -

25.0

D3407041

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number
1 D3407-041

Description
TOW RING

Batch

B30394 -

26.0

D34173

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number
2 D3417-3

Description
WASHER

Batch

B33519 -

Handwritten signature/initials

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 07/09/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 4:09:55 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 33973

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

D34561

washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1

D3456-1

WASHER

B 33276

28.0

AN4C7A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch: M101427

29.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-742-013

Location: D

31.0

QC21

FINAL INSPECTION W/O RELEASE



Comment: FINAL INSPECTION W/O RELEASE

Job Completion



W. A. J. 13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____



QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date Wednesday, 15/08/2007 4:10:11 PM
User Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOAT SKID ASSEMBLY
Jot Number	: 33973A		
Est. mate Number	: 10756		
P.C. Number	: <i>N/A</i>	Part Number	: D412742043
This Issue	: 15/08/2007	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D3391 REV F
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: 33972A	Drawing Revision	: F
	Type : LANDING GEAR	Material	: <i>N/A</i>
Written By	: 	Due Date	: 10/09/2007
Checked & Approved By	: 	Qty:	1 Um: Each
Comment	: Est Rev A 05.10.13 New Issue KJ/JLM : Est Rev B 06.02.13 ECN 773 dwg @ rev.D EC : Est Rev:C 07-05-28 As per Rev F JLM		

Additional Product

Jot Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

If D412-742-043 is a W/O on it's own,

Photocopy bluefile and create labels per PPP D412-742-043 CHG003 *N/A*

2.0	D3391023	Mid Tube Assembly
-----	----------	-------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

pick:

Qty Part Number Description Batch

1 D3391-023 Mid Tube Assembly

B 32234

3.0	D3391025	Aft Tube Assembly
-----	----------	-------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

pick:

Qty Part Number Description Batch

1 D3391-025 Aft Tube Assembly

B 33646

4.0	D35641	WEARSHOE
-----	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARSHOE

Batch:

*B 33243**M-h 07/08/24*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 4:10:11 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 33973A

Part Number: D412742043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D35643

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARSHOE

Batch:

B33764

M-L

6.0

D35645

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARSHOE

Batch:

B33802

M-L

7.0

D35661

GASKET



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

GASKET

Batch:

B33458

M-L

8.0

D35665

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GASKET

Batch:

B33483

M-L

9.0

AN3C4A

BOLT



Comment: Qty.: 24.0000 Each(s)/Unit Total: 24.0000 Each(s)

BOLT

Batch:

M105143

M-L

10.0

AN3C6A

BOLT



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

BOLT

Batch:

M103693

M-L

11.0

AN3C7A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

BOLT

Batch:

M103668

M-L 07/08/24

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 4:10:11 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 33973A

Part Number: D412742043

Job Number:



Seq. #:

Machine Or Operation:

Description:

12.0

AN960C10L

washer



Comment: Qty.: 44.0000 Each(s)/Unit Total: 44.0000 Each(s)

washer

Batch:

M 10 5143

M-A

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Spray inside tube of D3391-021/-023/-025 with LPS-3 as per Dwg D3391

A/R LPS-3

M 104161

2-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins.

A/R Sikaflex-241/-291

M 104989

Expiry date:

08-01

3-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Coat bolts with LPS "procyon".

Seal all bolts with sikaflex except ones with inserts on inside of tube ,hand tighten only bolts with no sikaflex.

A/R LPS Procyon

M 104261

A/R Sikaflex-241/-291

M 104989

Expiry date:

08-01

4-Remove "T" pins once sikaflex is dry.

5-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.

07/08/04

M-A

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/08/04

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-742-043

Location:

PPP Rev:

1PP 33973A

07/8/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 07/09/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 4:10:11 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 33973A

Part Number: D412742043

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Handwritten signature and date: 15/08/13

Job Completion



Handwritten signature and date: 15/08/13

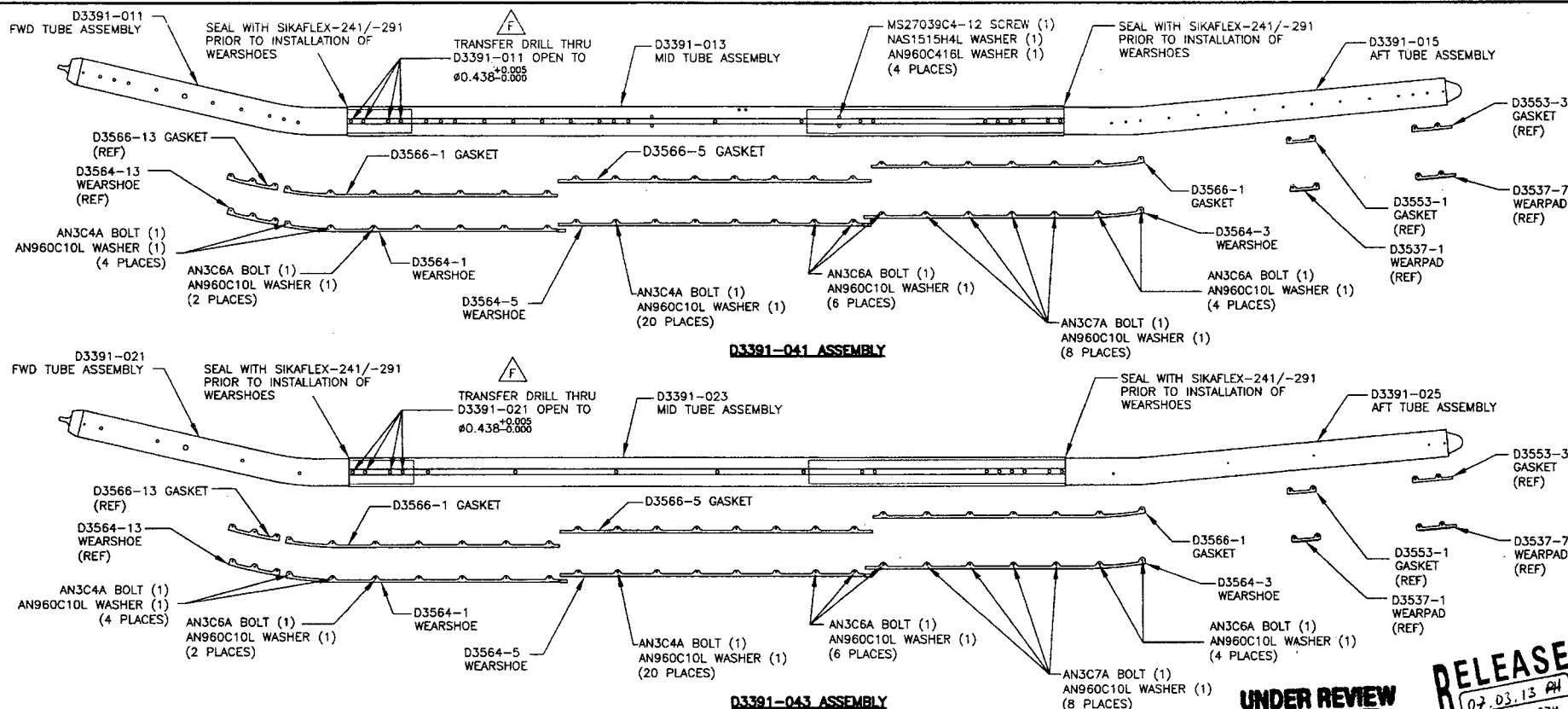
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-043		
X	X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
		D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	1	D3391-011	FWD TUBE ASSEMBLY
1	1	D3391-013	MID TUBE ASSEMBLY
1	1	D3391-015	AFT TUBE ASSEMBLY
1	1	D3391-021	FWD TUBE ASSEMBLY
1	1	D3391-023	MID TUBE ASSEMBLY
1	1	D3391-025	AFT TUBE ASSEMBLY
1	1	D3564-1	WEARSHOE
1	1	D3564-3	WEARSHOE
1	1	D3564-5	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
24	24	AN3C4A	BOLT
12	12	AN3C6A	BOLT
8	8	AN3C7A	BOLT
44	44	AN960C10L	WASHER
4	4	MS27039C4-12	SCREW
4	4	NAS1515H4L	WASHER
4	4	AN960C416L	WASHER

GENERAL NOTES

- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 'E' SIZE HOLES (Ø0.250-Ø0.257) FOR WEARSHOE INSERTS. C'SINK Ø0.391/Ø0.425 x 100' AS APPLICABLE AND INSTALL INSERTS EXCEPT WHERE INDICATED.

4/033973A

UNDER REVIEW
C7, 07, 30 DC
CHANGING INSERTS

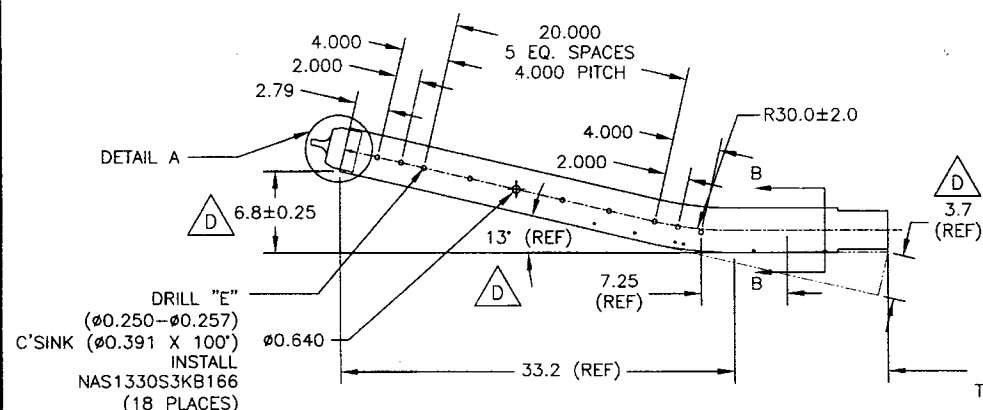
RELEASED
07.03.13 AH
PER ECU #934

F	07.01.18	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021
E	06.04.25	CHANGE TOLERANCE, EASE MANUFACTURE
D	06.01.23	UPDATE TOLERANCE, CHANGE HOLE SIZE
C	05.09.27	LENGTHEN AFT EXTENSION
B	05.06.10	DRAWING UPDATES
A	05.02.07	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D3391
DATE	TITLE	SCALE
07.01.18	412 FLOAT SKIDTUBE	NTS

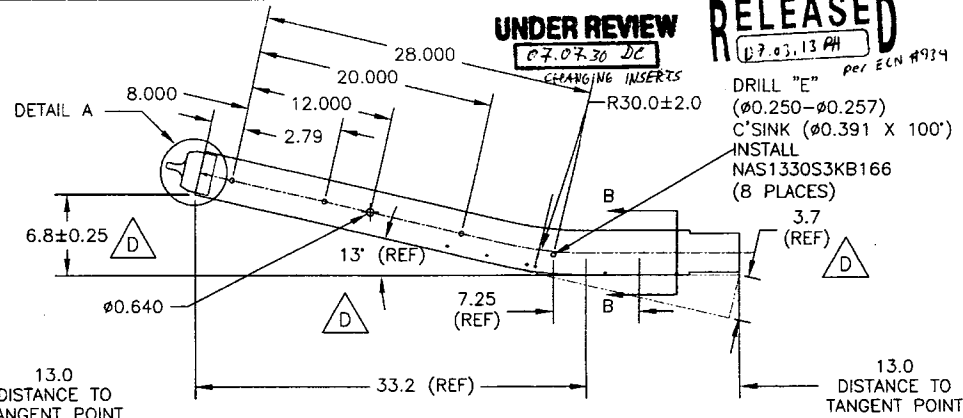
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DART AEROSPACE USA, INC.

UNDER REVIEW

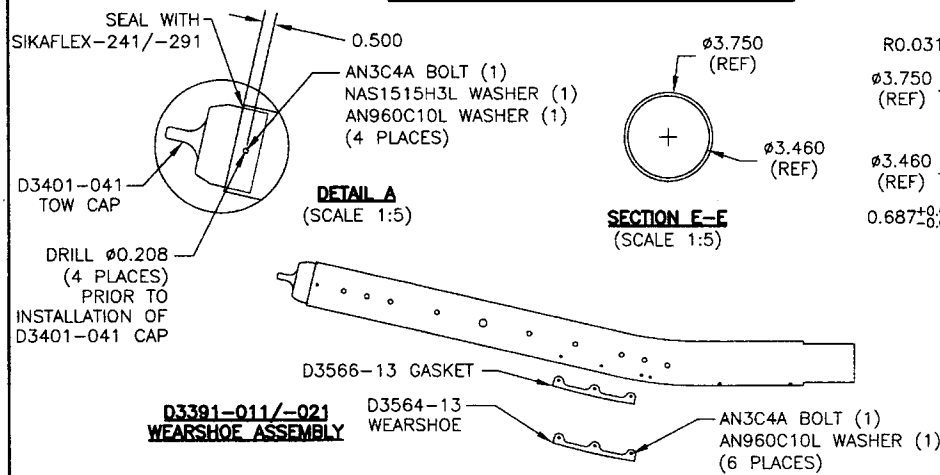
RELEASED
07.07.30 DC
07.03.13 AH
per ECLN #934



D3391-011 ASSEMBLY AND BENDING DETAIL



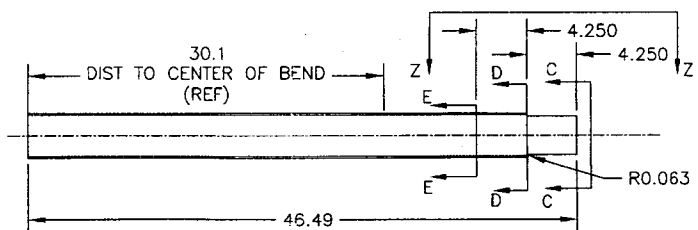
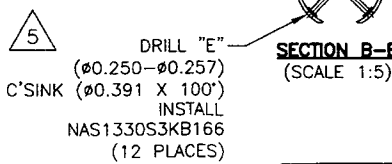
D3391-021 ASSEMBLY AND BENDING DETAIL



D3391-011/-021 WEARSHOE ASSEMBLY

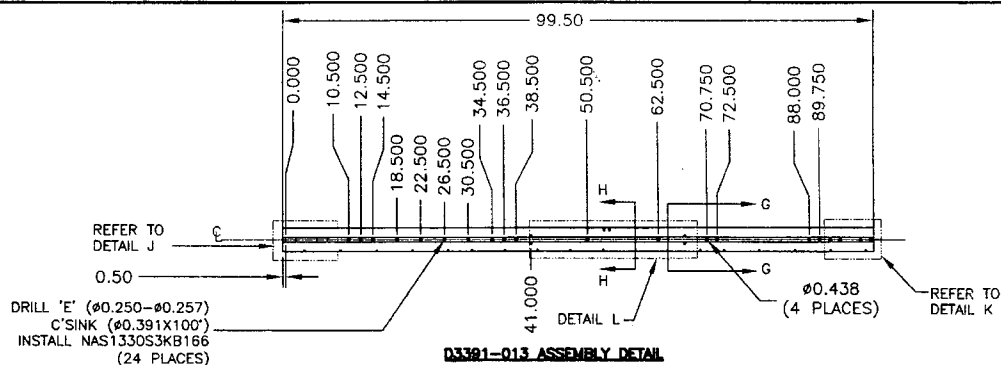
D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST

QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X	X	D3391-011	FWD TUBE ASSEMBLY
X	X	D3391-021	FWD TUBE ASSEMBLY
1	1	D6013-047	FWD TUBE
1	1	D3401-041	TOW CAP
1	1	D3564-13	WEARSHOE
1	1	D3566-13	GASKET
10	10	AN3C4A	BOLT
4	4	NAS1515H3L	WASHER
10	10	AN960C10L	WASHER
30	20	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)

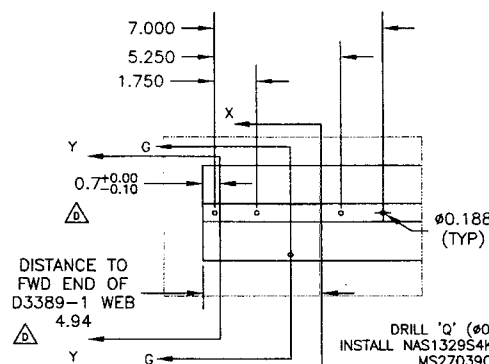


D3391-1 DRILLING AND CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)

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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3391		REV. F SHEET 2 OF 5	
DATE 07.01.18		TITLE 412 FLOAT SKIDTUBE		SCALE 1:10	

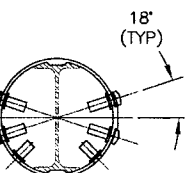
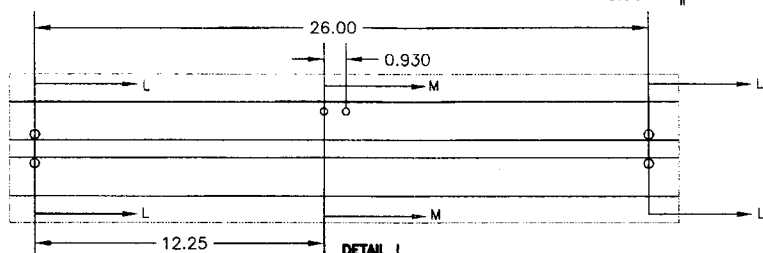


D3391-013 ASSEMBLY DETAIL

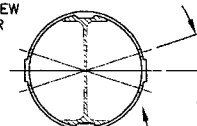


DETAIL J
(SCALE 1:5)

DRILL 'O' (#0.332-#0.338)
INSTALL NAS1329S4KB140 INSERT
MS27039C4-08 SCREW
NAS1515H4L WASHER
AN960C416L WASHER
(TYP 4 PLACES)

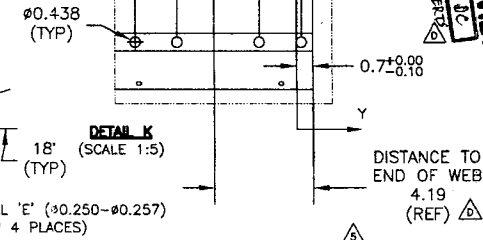


DRILL 'E' (#0.250-#0.257)
C'SINK (#0.391X100")
INSTALL NAS1330S3KB116 INSERT
MS27039C1-09 SCREW
NAS1515H3L WASHER
AN960C10L WASHER
(TYP 4 PLACES)

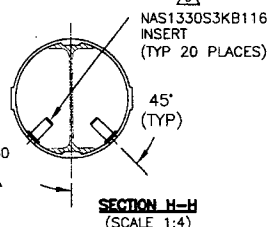


DRILL 'E' (#0.250-#0.257)
(TYP 4 PLACES)

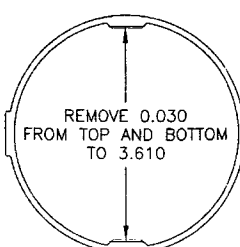
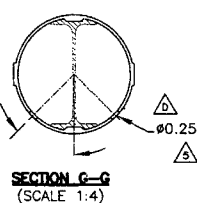
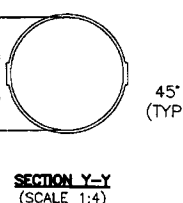
SECTION L-L
(SCALE 1:4)



DETAIL K
(SCALE 1:5)



REMOVE 0.225
FROM TOP AND BOTTOM
TO 3.800
(0.7 FROM BOTH ENDS)



D3391-013/-023 MID TUBE ASSEMBLY PARTS LIST

QTY - 013	QTY - 023	PART NUMBER	DESCRIPTION
X	X	D3391-013	MID TUBE ASSEMBLY
		D3391-023	MID TUBE ASSEMBLY
1	1	D2500-1-100	EXTRUSION
1	1	D3389-1	WEB
24	20	NAS1330S3KB116	INSERT (OR NAS1330C3KB116)
24	10	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)
4		NAS1329S4KB140	INSERT (OR NAS1329C3KB140)
4		NAS1515H3L	WASHER
4		AN960C10L	WASHER
4		NAS1515H4L	WASHER
4		AN960C416L	WASHER
4		MS27039C1-09	SCREW
4		MS27039C4-08	SCREW

D3391-013/-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015

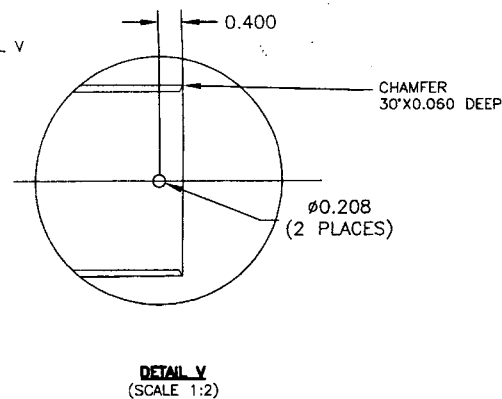
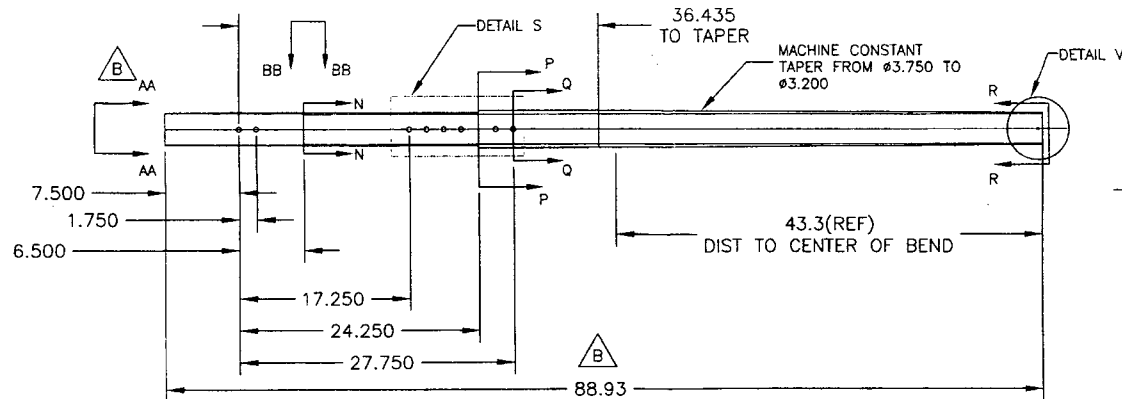
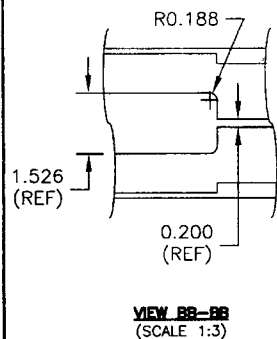
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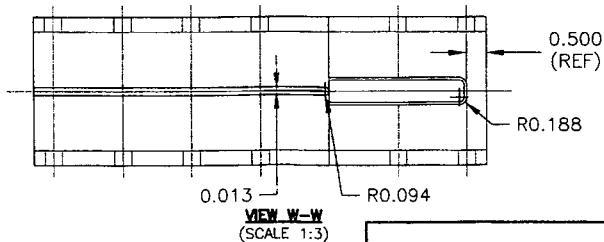
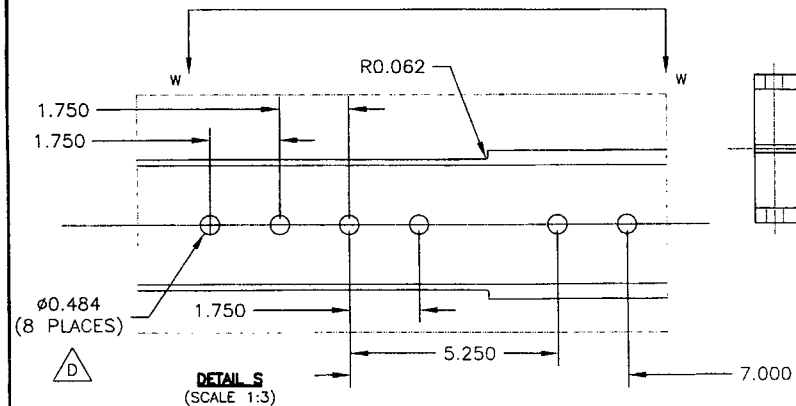
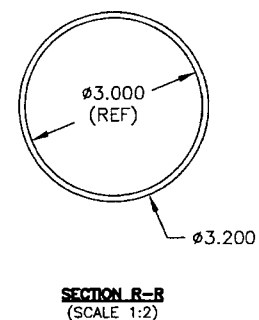
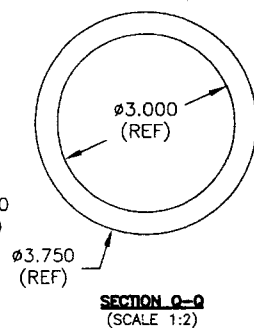
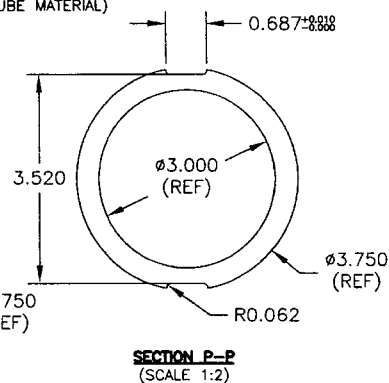
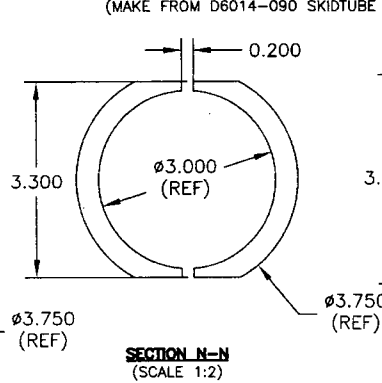
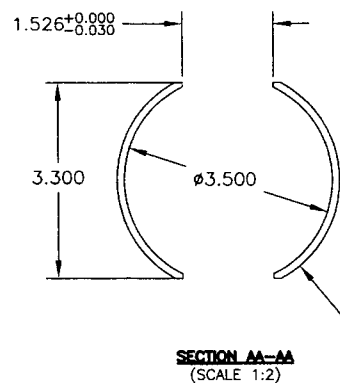
DESIGN	RAH	DRAWN BY	RAH	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA	REV. F
CHECKED	RAH	APPROVED	RAH	DRAWING NO. D3391	SHEET 3 OF 5
DATE	07.01.18	TITLE	412 FLOAT SKIDTUBE	SCALE	1:20

RELEASED
07.05.13 RH
DET E-LN #934

UNDER REVIEW
07.07.30 AC
CHANGING INSERTS



D3391-3 AFT DRILLING AND CUTTING DETAIL
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)



UNDER REVIEW
07.07.30 DC
CHANGING INSERTS

RELEASED
07.03.13 PH
per ELN #934

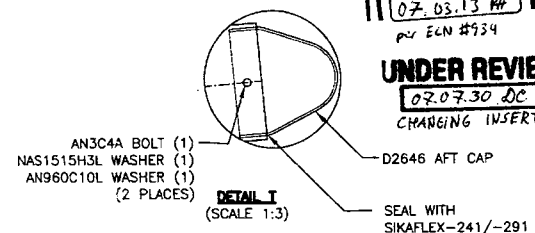
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		DATE 07.01.18	TITLE 412 FLOAT SKIDTUBE		SCALE 1:12



QTY - 015 X	QTY - 025	PART NUMBER	DESCRIPTION
	X	D3391-015	AFT TUBE ASSEMBLY
		D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
18	14	NAS1330S3KB366	INSERT (OR AES10KB366)
4	2	NAS1330S3KB316	INSERT (OR NAS1330C3KB316)
8	6	NAS1330S3KB266	INSERT (OR NAS1330C3KB266)
4		NAS1330S3KB216	INSERT (OR NAS1330C3KB216)
16	12	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)
4		NAS1330S4KB151	INSERT (OR NAS1330C4KB151)
6	6	AN3CAA	BOLT
4	4	AN3CSA	BOLT
2	2	NAS1515H3L	WASHER
10	10	AN960C10L	WASHER



DRILL 'Q' ($\phi 0.332 - \phi 0.338$)
C'SINK ($\phi 0.529 \times 100^\circ$)
NAS1330S4KB151 INSERT (1)
(4 PLACES)



C/SINK AND INSTALL NAS1330S3KBXXX IN HOLES MARKED CS1-CS6 AS FOLLOWS

HOLES MARKED	QTY D3391-015	QTY D3391-025	C-SINK	P/N
C51	18	14	Ø0.425	NAS1330S3KB366
C52	4		Ø0.391	NAS1330S3KB366
C53	4	2	Ø0.391	NAS1330S3KB316
C54	8	6	Ø0.391	NAS1330S3KB266
C55	4		Ø0.391	NAS1330S3KB216
C56	16	12	Ø0.391	NAS1330S3KB166

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DRAWN BY

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DRAWING NO	
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REV.

4

1

03391

SHEET 6 OF 6

DATE _____

DATE	
TIME	

SCA

07.01.18

412 FLOAT SKIDTUBE

1:

RELEASED
07.03.13 RH
per EGN #934
UNDER REVIEW
07.07.30 DC
CHANGING INSERTS